Work Orde February-12-14	er ID 113073 8:14:17 AM		*113	307.3*							Page 1	L
Item ID: Revision ID:	D3463-041		Accept	*N900	040	100)*	Setup	Start	*N	S1*	
Item Name:	Step Weldment Assembly	. 1	***	٠					Stop	*\	S2*	
Start Date: Required Date: Reference:	2/10/14 Start Qty: 2.0 Req'd Qty: 2.0	1 1/		Cust Item 1 Customer:	ID:							
Approvals:	Process Plan: MJ	Date: <u>\4-02-\</u> 'う	Tooling:	D	ate:	_]	Run	Start	*N	R1*	
	QC:	Date:	SPC (Y/N):	D	ate:				Stop	*N	R2*	
Sequence ID/ Work Center II	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp	
Draw Nbr	Revision Nbr	·										
D3463	Rev B										14-0	17-1
100	Large Fab		0.00				6				14-0	_ 1BL
Large Fab Large Fab	***Lea drain w	ssembly as per dwg D3463 using ve a small none welded area on e ater***	0.00 DT8875 ach side bottom of D34	63-3 step to							Dan	
110	QC9- Inspect visual	per QS1004- Fusion Welds	0.00				<i>P</i>		.		Das 24	
110 QC Quality Control	Memo		0.00			.·	6		<u>14</u>	<u>17.7</u>	9-89	·
120 *120*	QC5- Inspect part co	ompleteness to step on W/O	0.00				6		jΉ	1.7.7	DAS 24 9-89	
QC Quality Control	Memo		0.00				<u> </u>			/		

DQA:		Date	:									TO A DT
QA Closed:		Date			WORK ORDER NON-	-C(ONFO	RMANCE / UPDAT		ork Order:uı	ndata anlu	AEROSPACE
QA Closeu.		Date	<u> </u>				<u> </u>		VV	ork Order u	odate only	
Work Orde	er:				DISPOSITION	-		AG	SAINST DE	PARTMENT	/PROCESS	
					Rework			Skid-tube Cros	sstube	1	Water Jet	Engineering
Part N	No.		••		Scrap			—	all Fab	Pro	d. Eng. Coor.	Quality
	-				/ Use-as-is		Thern	noforming Fin	nishing	Rec/Sto	re/Packaging	Other
NCR N	No				Suspected Unapproved			Large Fab Com	posite		Supplier	
					,					_		
Root				Desci	ription of work order update		Initial	Action		Sign &		
Cause	Dat	e Step	Qty		or non-conformance	Ch	nief Eng	Description		Date	Verificatio	n QC Inspector
Design												
Doc/Data												
Equip/Tooling												
Handling/Pre											**	
Material								·			·	
Operator			-									
Offset/Setup												
Process												
Supplier	_											İ
Training Transport	-											
Unapproved									•			
i.	<u> </u>	<u> </u>	<u> </u>	<u> </u>		FΔI	UIT CAT	TEGORY		13,		I
Landii	ng Gear	<u> </u>			General	-	<u> </u>	120011	***************************************			
	Bendi	ng			Bend		Folio/P	rogram		Outside Dim	ensions	Pressure/Forced
	_	e Not Conce	ntric		BOM/Route		Grain			Over/Under		Set-up
	Crack	5			Broken/Damage/Defect		Hardwa	re	ļ	Part Incorred		Temperature/Cure
ફ હ	Crimp	/Kink/Ripple	e/Wave		Burrs		Inspecti	on Incomplete/Unqualifie	ed	Part Lost/Mi	ssing	Weld
3m =	Cuffs				Contamination		Instruct	ions Incomplete/Unclear		Part Moved		Wrong Stock Pulled
C.	Crush	ing			Countersink		Misalig	ned/off center		Positioned V	Vrong '	
~-	Heat ⁻	reat			Cut Too Short		Mislabe	led		Power Loss/	Surge	Other
	Inspe	ction Strip ir	Tube		Drawing		Misread	· · · · · · · · · · · · · · · · · · ·				
	Marks	/Chatter			Drill Holes		Off-set					
		ng Sequence		·	Finish	Ĺ	Out of 0	Calibration				
	Wave	/Twist in Tu	be		Fit/Function	L	Out of S	Sequence				

150

QC3- Inspect Part Finish

0.00

*15**0***

Memo

0.00

Quality Control

DQA:			Date:											TOART
						WORK ORDER NON-	-C(ONFO	RMANCE / UPDATE					AEROSPACE
QA Closed:			Date:							Wo	ork Order up	odate only		
Work Orde	er:					DISPOSITION			AGAINST	DE	PARTMENT	/PROCESS		
	•					Rework			Skid-tube Crosstube			Water Jet		Engineering
Part N	٧o.					Scrap			Machining Small Fab	-	Pro	d. Eng. Coor.	_	Quality
		, _				Use-as-is		Therr	moforming Finishing	П		re/Packaging		Other
NCR I	No.					Suspected Unapproved			Large Fab Composite			Supplier		
			, , , , , , , , , , , , , , , , , , , 											
Root					Desci	ription of work order update		Initial	Action		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	1	QC Inspector
Design														
Doc/Data						·								
Equip/Tooling	Н													,
Handling/Pre	_													
Material	\Box													
Operator	\dashv	:												
Offset/Setup Process						•								•
Supplier	\dashv													
Training	\dashv		i											•
Transport	-					·								
Unapproved														
		, , , , , , , , , , , , , , , , , , , ,	I				FAI	ULT CA	TEGORY					<u> </u>
Landi	ng G	Gear				General		_						
		Bending				Bend .		Folio/F	Program		Outside Dim	ensions		Pressure/Forced
		Centre No	ot Concen	itric		BOM/Route		Grain			Over/Under	tolerance		Set-up
		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorred	:1		Temperature/Cure
	`	Crimp/Kir	ık/Ripple,	/Wave		Burrs ·		Inspect	ion Incomplete/Unqualified		Part Lost/Mi	ssing		Weld
		Cuffs				Contamination		Instruc	tions Incomplete/Unclear		Part Moved			Wrong Stock Pulled
	-	Crushing				Countersink	-	1 '	gned/off center	-	Positioned W	· ·		•
	\blacksquare	Heat Trea			<u> </u>	Cut Too Short	-	Mislab			Power Loss/S	Surge		Other
	_	Inspection	·-	Tube		Drawing	$\overline{}$	Misrea						
	\vdash	Marks/Ch				Drill Holes		Off-set						
		Turning S				Finish		ł	Calibration					
		Wave/Tw	ist in Tub	e	. 1	Fit/Function		Out of	Sequence					

Work Order ID 113073 *113073* February-12-14 8:14:17 AM Item ID: D3463-041 Accept *N900040100* Setup Start **Revision ID:** Stop **Item Name:** Step Weldment Assembly *9* **Start Date:** 2/10/14 Start Qty: 2.00 **Cust Item ID:** Required Date: 2/10/14 **Req'd Qty: 2.00** *9* **Customer:** Reference: Start Run Approvals: **Process Plan:** Date: **Tooling:** Date: Stop Date: SPC (Y/N): Date: *NR2* Sequence ID/ **Operation** Set Up/ Reject Tool ID Tool# Reject Plan Accept **Work Center ID Description** Number **Run Hours** Qty Code Qty Identify as per dwg & Stock Location 160

160 Packaging

Packaging

Memo

0.00

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

MLS 14.07-09

Page 3

Insp.

Stamp

DQA:			Date:						•						TAAPT
OA Clasadi			Datas			WORK ORDER NON	-C(ONFO	RMANCE / UP	PDATE	14/	lank Ondan			AEROSPACE
QA Closed:			Date:								VV	ork Order u	poate only		
Work Orde	er:					DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
	•				_	Rework	1		Skid-tube	Crosstube		7	Water Jet		Engineering
Part N	No.					Scrap			Machining	Small Fab	_	Pro	d. Eng. Coor.		Quality
	•					Use-as-is	1		noforming	Finishing		4	re/Packaging		Other
NCR N	۷o.					Suspected Unapproved			Large Fab	Composite			Supplier		
					_					•••			. -		
Root					Desci	ription of work order update		Initial	Acti	on		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Descri	ption		Date	Verification	1	QC Inspector
Design	Щ														
Doc/Data							'								
Equip/Tooling															
Handling/Pre	Щ														
Material															
Operator	\Box				'										
Offset/Setup															
Process	_		-			•									·
Supplier	Щ														,
Training	_														
Transport	_					•			·						
Unapproved					l								1		
1		`					FA	ULI CA	regory						
Landi		Bending				General Bend		ارمانه رر	rogram	1		Outside Dim			Pressure/Forced
	\vdash	Centre No	ot Concon	.tric	E.Q.	BOM/Route		Grain	Togram		-	Over/Under	-	_	Set-up
		Cracks	or concer	itiic	-	Broken/Damage/Defect	\vdash	Hardwa	uro.			Part Incorre			Temperature/Cure
	-	Crimp/Kir	nk/Rinnla	/\ <i>M</i> 2\\Q	\vdash	Burrs		4	ine ion Incomplete/Un	austified	_	Part Lost/Mi	⊢		Weld
		Cuffs	iky itippie,	, wave		Contamination		1	ions Incomplete/U	-		Part Moved	1331118		Wrong Stock Pulled
		Crushing			-	Countersink	<u> </u>	4	ned/off center	, roicui		Positioned V	L Vrong ·		The state of the s
	-	Heat Trea	ıt			Cut Too Short	-	Mislabe			-	Power Loss/			Other
	-	Inspection		Tube		Drawing	H	Misrea				٦. ٥٠٠٥، عمر			1
	$\overline{}$	Marks/Ch				Drill Holes	H	Off-set					* *		
		Turning S				Finish	T	-	Calibration						
	Г	Wave/Tw				Fit/Function		4	Sequence						

Page 1

Work Order ID: 113073

113073

Parent Item:

D3463-041

D3463-041

Parent Item Name: Step Weldment Assembly

Start Date: 2/10/14

Required Date: 2/10/14

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP REV. A 05.11.18 new issue

EC

IPP revB: replace pressure

Component Item ID/ tem Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
8-806		Purchased	No			100	Each	146.0000	2	4			
238-806* DOWEL PIN 1" LONG									**				14-06
				Location		Loc	<u>Oty</u>	Loc Code					
				ST396			100		• –		_		
					M127628		100		_		- .		
				WA002	M120110		46 46		_	112	_		
53-3		Manufactured	No	1	M120119	100	Each	1.0000	_ 1	2	_		~
)3453-3*		Manufactured						210000	**	2			<i>160</i>)
is				•					_				
. 1		-		Location		Loc	Oty	Loc Code	2	77			14-06
				WA002 ₹	98933		1 1			16	_		14-06
53-5		Manufactured	No			100	Each	50.0000	1 .	2			•
73453-5*									**				14-0
5				Location		Loc	Oty	Loc Code				٠	1
				WA001			19		_		_		/
•					109132		19		-		_		
				WA002			31		4	<u>u</u> ,	_		

109132 97133 20 11

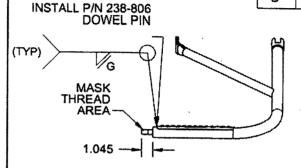
DQA:	······	Date:													
04 Classide		Data			WORK ORDER NON	-CC	NFO	RMANCE / U				AEROSPACE			
QA Closed:		Date:							V	Vork Order ι	pdate only				
Work Orde	r:				DISPOSITION	ı			AGAINST D	EPARTMEN'	r/PROCESS				
	•			_	Rework	1		Skid-tube	Crosstube		Water Jet	Engineering			
Part N	0.				Scrap	1		Machining	Small Fab	Pro	od. Eng. Coor.	Quality			
	·				Use-as-is	1		noforming	Finishing	_	re/Packaging	Other			
NCR N	o				Suspected Unapproved]		Large Fab	Composite		Supplier				
Root			ì	Descr	ription of work order update		nitial	Δς:	tion	Sign &					
Cause	Date	Step	Qty	<i>D</i> c s c i	or non-conformance	ı	ief Eng	1	ription	Date	Verification	QC Inspector			
Design		3334				0111	ici ciig	2000	. ipcion		Vermication	QC IIISPECTOI			
Doc/Data								·			•				
Equip/Tooling	1					,									
Handling/Pre											·				
Material			Ì												
Operator												,			
Offset/Setup			,					;							
Process											-				
Supplier															
Training	_									İ					
Fransport	_							÷							
Jnapproved	<u>_ L</u>	<u> </u>	<u> </u>			<u> </u>									
						FAU	JLT CAT	regory							
Landin	_				General				_	_		٦ ا			
Į.	Bending				Bend	\vdash	-	rogram	<u>. </u>	Outside Din		Pressure/Forced			
	Centre No	ot Concer	ntric	—	BOM/Route	Н	Grain		_	Over/Unde	<u></u>	Set-up			
}-	Cracks				Broken/Damage/Defect	_	Hardwa		<u>.</u>	Part Incorre		Temperature/Cure			
	Crimp/Kir	ık/Ripple	/Wave	—	Burrs	$\boldsymbol{\vdash}$	•	ion Incomplete/U	· -	Part Lost/M		Weld			
	Cuffs			_	Contamination	_		ions Incomplete/	Unclear –	Part Moved		Wrong Stock Pulled			
-	Crushing			. —	Countersink	-		ned/off center	<u> </u>	Positioned		Joshan			
-	Heat Trea		Tuba		Cut Too Short	-	Mislabe		L	Power Loss	'Surge	Other			
-	Inspection Marks/Ch	=	rupe		Drawing Drill Holes	-	Misread								
-	Turning S				Finish	$\boldsymbol{\vdash}$	Off-set	Calibration							
-	Wave/Tw			-	Fit/Function	-		Seguence							

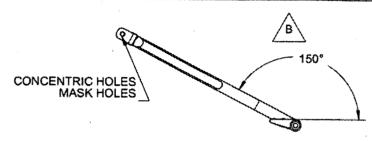
Picklist Print February-12-14 8:14:20 AM			:	Page 2
Work Order ID: 113073 Parent Item: D3463-041 Parent Item Name: Step Weldment Assembly	*113073* *D3463-041*		Start Date: 2/10/14 Start Qty: 2.00	Required Date: 2/10/14 Required Qty: 2.00
D3463-1 Manufactured	No	100 Each	5.0000 1 2	
D3463-1			**	14-06-2
Arm	Location WA002 (103))	<u>Loc Qty</u> 5 5	Loc Code \[\lambda \]	14-06-2 JB
D3463-3 Manufactured *D3463-3*	No	100 Each	13.0000 1 2	14-06-27
Step ,	Location WA002 (11130) 100938	Loc Oty 13 6 6	Loc Code	BL
D3463-5 Manufactured	97166 No	1 100 Each	41.0000 2 4	- ,
D3463-5 Manufactured *D3463-5* End Cap	NU	100 Each	41.0000 2 4	14-07-
Eud Cap	Location WA002 100476 97231	Loc Oty 41 12 29	Loc Code	/15 / - -
D3463-7 Manufactured	No (2)/231 }	100 Each	7.0000 1 2	-
D3463-7			**	14-07-0 15
	Location WA002 (10769) 103584	<u>Loc Qty</u> → 7	Loc Code Code	-

DQA:	QA: Date:				- ΔART											
QA Closed:		Date:			WORK ORDER NON	-C(ONFO	RMANCE / UF		Vork Order u	pdate only	AEROSPACE				
Work Orde	\r.		_		DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	•				
Part N	lo.				Rework Scrap Use-as-is			Skid-tube Machining moforming	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other				
NCR N	lo. <u> </u>				Suspected Unapproved]		Large Fab	Composite		Supplier					
Root				Desc	ription of work order update	1	Initial	Acti		Sign &						
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	iption	Date	Verification	QC Inspector				
Design								ļ				}				
Doc/Data	_															
quip/Tooling	_															
Handling/Pre												•				
Material						ĺ				·		Ť				
Operator																
Offset/Setup				1				▲ ^								
Process												·				
Supplier					•				•							
Fraining																
Transport	_											,				
Jnapproved			<u> </u>								<u></u>					
						FAI	ULT CA	TEGORY								
Landir	ng Gear		٠.	٠.	General		-	*	_	_		<u> </u>				
1	Bending				Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced				
	Centre No	ot Conce	ntric		BOM/Route		Grain		· L	Over/Under	tolerance	Set-up				
	Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorre	cí <u> </u>	Temperature/Cure				
Ĺ	Crimp/Kir	nk/Ripple	/Wave		Burrs	L	Inspect	ion Incomplete/Un	qualified	Part Lost/Mi	issing	Weld				
	Cuffs				Contamination	L	Instruct	tions Incomplete/U	Inclear	Part Moved		Wrong Stock Pulled				
1	Crushing				Countersink		Misalig	gned/off center		Positioned V	Vrong	-1 si.				
	Heat Trea	t			Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other				
1	Inspection	n Strip in	Tube		Drawing		Misrea	d			<u> </u>					
Į	Marks/Ch	atter		L	Drill Holes		Off-set			-						
	Turning S	equence			Finish		Out of	Calibration								
ſ	Wave/Tw	ist in Tuk	10		Fit/Function		Out of	Seguence		<u>.</u>						



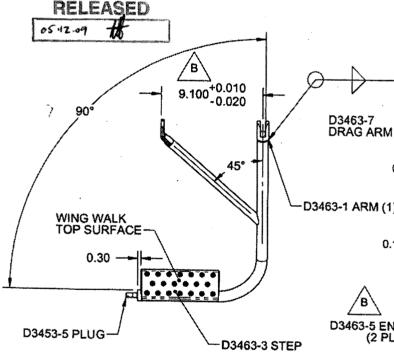
DESIGN DRAWN BY DART AEROSPACE LTD RF RF HAWKESBURY, ONTARIO, CANADA CHECKED APPROVED A DRAWING NO. REV. B D3463 SHEET 1 OF 4 DATE TITLE SCALE 05.12.05 STEP WELDMENT 1:8 A 05.09.20 **NEW ISSUE** В 05.12.05 REVISE DIM.: D3463-5 WAS D3463-5F

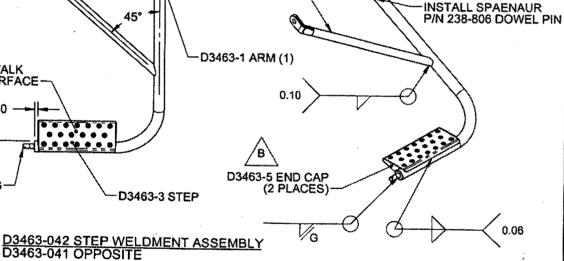




D3453-3 CLEVIS

(TYP)





NOTES:

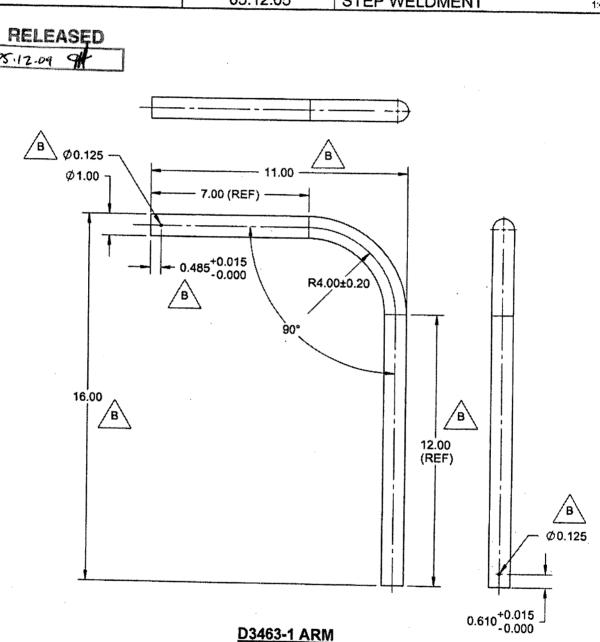
- 1) WELD PER DART QSI 004
 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
 BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) ALL DIMENSIONS ARE IN INCHES
 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN RF	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA							
CHECKED	APPROVED	DRAWING NO. D3463	REV. B						
DATE 05.1	2.05	STEP WELDMENT	SCALE						



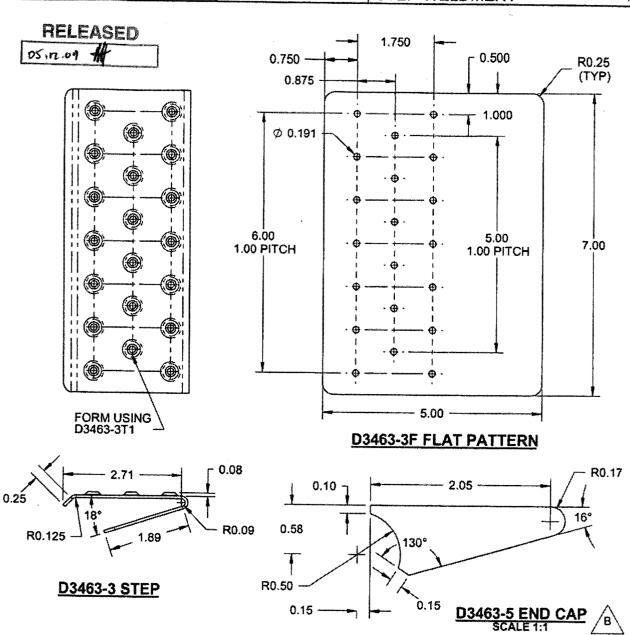
NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR1.000W.120) 2) FINISH: NONE 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 4) ALL DIMENSIONS ARE IN INCHES 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

COPYRIGHT © 2005 BY DART AEROSPACE LTD.



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA							
CHECKED	APPROVED	D3463	REV. B						
DATE 05.1	12.05	STEP WELDMENT	SCALE 1:2						



NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 2) FINISH: NONE
 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) ALL DIMENSIONS ARE IN INCHES
 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

COPYRIGHT © 2005 BY DART AEROSPACE LTD.